

Work Order ID 52686

October 7, 2009 10:24:59 AM



Page 1

Item ID: D3172-041
Revision ID: C
Item Name: Basket Base Assembly

Accept



Setup Start



Stop



Start Date: 07/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 15/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: PS Date: 09-10-7 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3172	Rev C

100 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut Qty 4 D3166-1 as per Dwg D3172-2-Cut 3/4" x 3/4" square tubing as per Dwg D3172-3-Drill holes in D3172-3 as per Dwg D3172 4-Debur & Remove all markings from material 5-Weld as per Dwg D3172 using Welding Table and corner Jig & D3172T1 Debur as r

110



QC9- Inspect visual per QSI004- Fusion Welds 0.00

QC

Memo

0.00

Quality Control

120



QC6- Inspect dimensions to drawing 0.00

QC

Memo

0.00

Quality Control

27 509/10/20

SM 09/10/16 (1x)

CP 05/10/19



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Item ID:	D3172-041	Accept		Setup	Start	
Revision ID:	C				Stop	
Item Name:	Basket Base Assembly					
Start Date:	07/10/2009	Start Qty:	1.00	Cust Item ID:		
Required Date:	15/10/2009	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M112260</i> Memo 1ST COAT: <i>2:00pm</i> START TIME: <i>2:00pm</i> OVEN TEMPERATURE: <i>400°F</i> FINISH TIME: <i>2:30pm</i> ***** 2nd coat if necessary ***** 2ND COAT: START TIME: <i>2:45pm</i> OVEN TEMPERATURE: <i>400°F</i> FINISH TIME: <i>3:15pm</i>	0.00 <i>Jef 09/10/20</i> 0.00				<i>(X)</i>	<i>8</i>		
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 <i>OK 09-10-21</i> 0.00				<i>Q</i>			

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Setup Start



Stop



Start Date: 07/10/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 15/10/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 Packaging	Identify as per dwg & Stock Location: _____ Memo	0.00 0.00	PAP 52680			9/10/22	50		
160 QC	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							
Quality Control									

09/10/22 HJ
PL 09-10-22

Picklist Print

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Work Order ID: 52686



Parent Item: D3172-041RevC



Parent Item Name: Basket Base Assembly

Start Date: 07/10/2009

Required Date: 15/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2012-117RevC Manufactured No

100 Each 30.0000 2.0000



Clevis

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

30

31101

2

52498

28

100 Each 11.0000 2.0000

D2232-3RevC

Manufactured No



Basket Hinge

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

8

50024

2

51870

6

Main Warehouse

WA

3

50986

3

2x 09/10/13

2x 09/10/13

Picklist Print

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Work Order ID: 52686



Parent Item: D3172-041RevC



Parent Item Name: Basket Base Assembly

Start Date: 07/10/2009

Required Date: 15/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2327-3RevD

Manufactured

No

100

Each

48.0000

2.0000



Spacer Bushing

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

48

44274

29

44365

9

51126

10

2x 8/09/10/13

D2581RevA1

Manufactured

No

100

Each

76.0000

2.0000



Mounting Bracket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

13

46086

2

48428

1

51120

10

Main Warehouse

WA

63

50872

14

51745

49

2x 8/09/10/13

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Shop Packet Print

Page 2

Picklist Print

October 7, 2009 10:24:59 AM

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Parent Item: D3172-041RevC



Parent Item Name: Basket Base Assembly

Start Date: 07/10/2009

Required Date: 15/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3166-1RevA1 Manufactured No

100 Each 22.0000 4.0000



Basket Hoop

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

WA

22

51248

7

51474

3

51951

12

3x
1x

SY 09/10/08

D3174-1RevA1 Manufactured No

100 Each 28.0000 8.0000



Mounting Lug

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

28

41632

28

3x

SY 09/10/13

Picklist Print

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Parent Item: D3172-041RevC

Parent Item Name: Basket Base Assembly

Start Date: 07/10/2009

Required Date: 15/10/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304EX0.75-16F		Purchased	No			100	sf	306.0011	48.0000			
Expanded Metal Flat SS												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	306.0011065	
110134	6.7	
110629	14.41	
111630	9.15	
111956	0.000017	
112147	54.8205895	Base x2
112311	28.9205	
112707	192	

SAD 09-10-15
SM 09/10/15

M304TS0.750W.065

Purchased

No

100

f

678.9022

53.6842



304 SQ Tube .75x.75x.065W

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
WA	678.9022	
112398	678.9022	

53.6842'

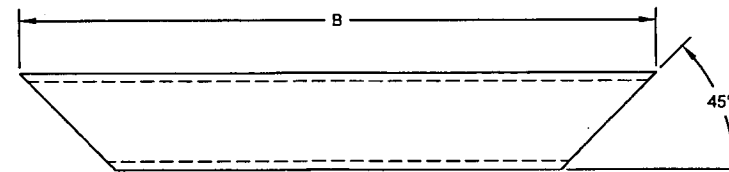
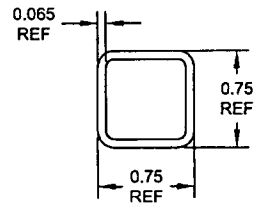
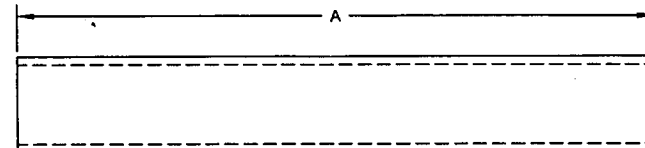
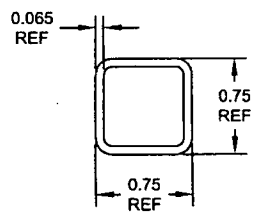
END BAR SCRAP 1' feet

SM 09/10/14

PARTS LIST FOR D3172-041 BASKET BASE ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3172-1	2	—	96.00	RIB
D3172-3	2	—	25.50	RIB
D3172-5	6	33.09	—	RIB
D3172-7	3	26.81	—	RIB
D3172-9	1	94.50	N/A	RIB
D2012-117	4	N/A	N/A	CLEVIS
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRACKET
D2232-3	2	N/A	N/A	HINGE PLATE
D3166-1	4	N/A	N/A	RIB
D3174-1	8	N/A	N/A	MOUNTING LUG

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 52684
RD 09-10-7

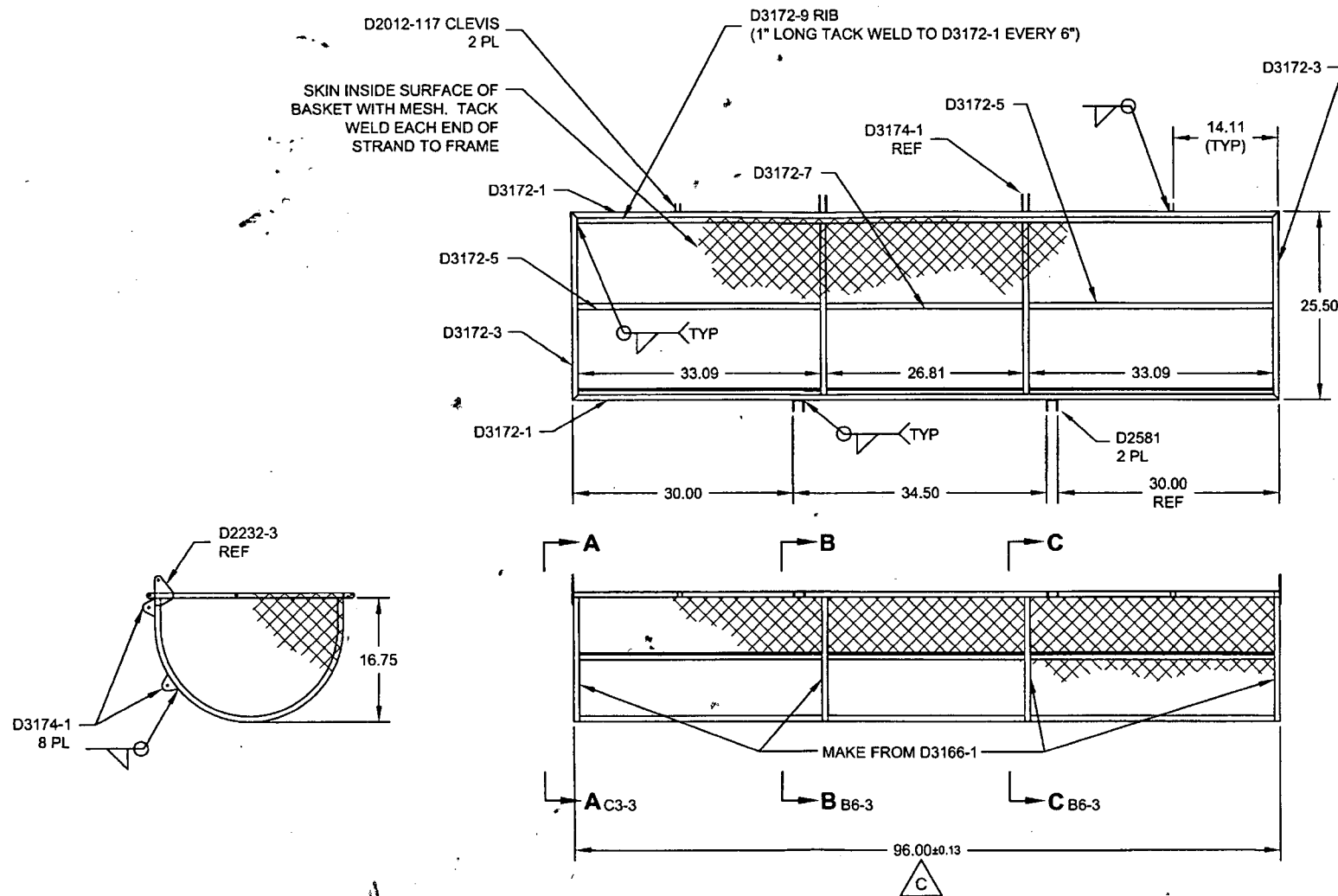


RELEASED
08-05-21/10

C

NOTES:
MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
UNITS: INCHES UNLESS OTHERWISE NOTED
BREAK SHARP EDGES: 0.005 TO 0.010 MAX
IDENTIFICATION: NONE
WEIGHT: N/A
WELD PER DART QSI 004

C	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.03
B	ADD D3172-9 & D2012-117	CP	03.01.07
A	NEW ISSUE	DS	02.12.02
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3172	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSEMBLY (EC130)	NTS
DATE	08.07.03	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

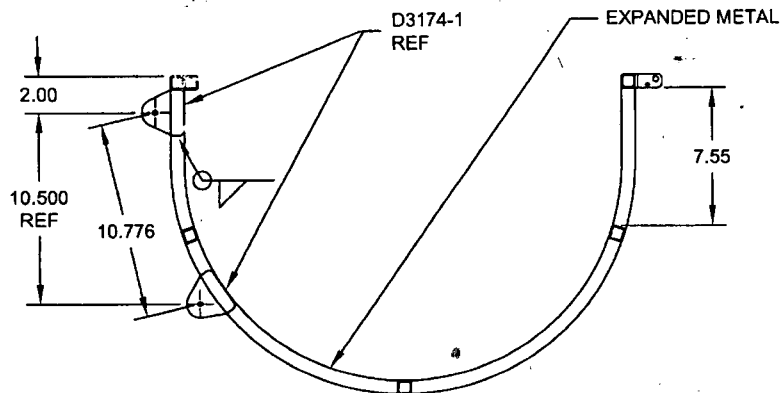


SHOP
 REVISION
 ENGINEERING
 UNCONTROLLED
 SUBJECT TO APPROVAL
 WITHOUT NOTICE
 WORK ORDER
 NO. 52684
PL 09-107

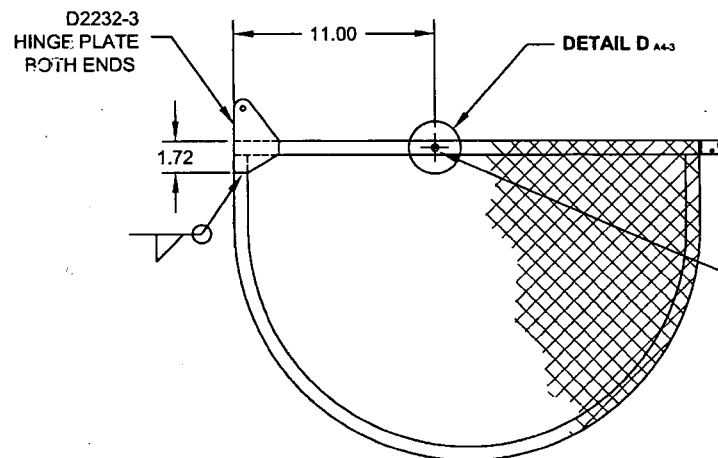
D3172-041 BASKET BASE ASSEMBLY

DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3172	SHEET 2 OF 3
APPROVED		TITLE	SCALE
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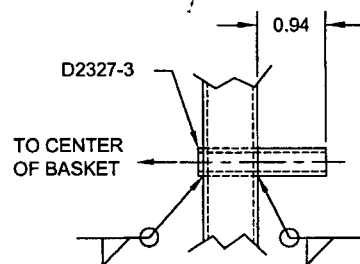
RELEASED



**SECTION B-B^{B5-2}
AND SECTION C-C^{B3-2}**
RIB DETAIL
SCALE 2X



SECTION A-A^{B5-2}
SPACER DETAIL
SCALE 2X



DETAIL D^{D3-3}
SCALE 4X

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08-08-21/11/20

DESIGN	CP	DART AEROSPACE LTD	
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MFG. APPR.		D3172	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (EC130)	NTS
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